

Date: Tuesday, 03/03/2009 4:17:18 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRONT OUTBOARD LEG (RH)
Job Number : 46288	
Estimate Number : 13377	
P.O. Number :	Part Number : D37684 <i>FR</i>
This Issue : 03/03/2009 S.O. No. :	Drawing Number : D3768 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 40974	Material :
Written By :	Due Date : 30/03/2009 Qty: 4 Um: Each
Checked & Approved By : <i>JD 09.03.04</i>	
Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-08-25 Rev B Added Drilling tooling JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W065

6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 0.8969 f(s)/Unit Total : 3.5876 f(s)
 6061T6 TUBE (1.00" x 0.65" wall)
 batch: _____

M111029 m-l 09/05/04

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(4X)

Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-CUT TUBE TO LENGH AS PER DWG D3768
 2-DRILL TUBE USING DT9044 AND AS PER DWG D3768
 3-DEBURR

m-l 09/05/04

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/05/05 (X4)

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

M 09-05-06 (X4)

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FL 09/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/03/2009 4:17:18 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT OUTBOARD LEG (RH)

Job Number: 46288

Part Number: D37684

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

8:55

OVEN TEMPERATURE:

320°

FINISH TIME:

9:25

F& 09/05/06

(4)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-06 JLT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Sylve ST480

JJ 09/05/06 (XU)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07 J

Job Completion



mf 09-05-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NO 40288

D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH

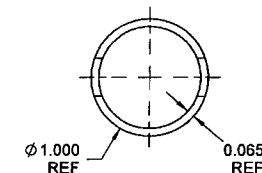
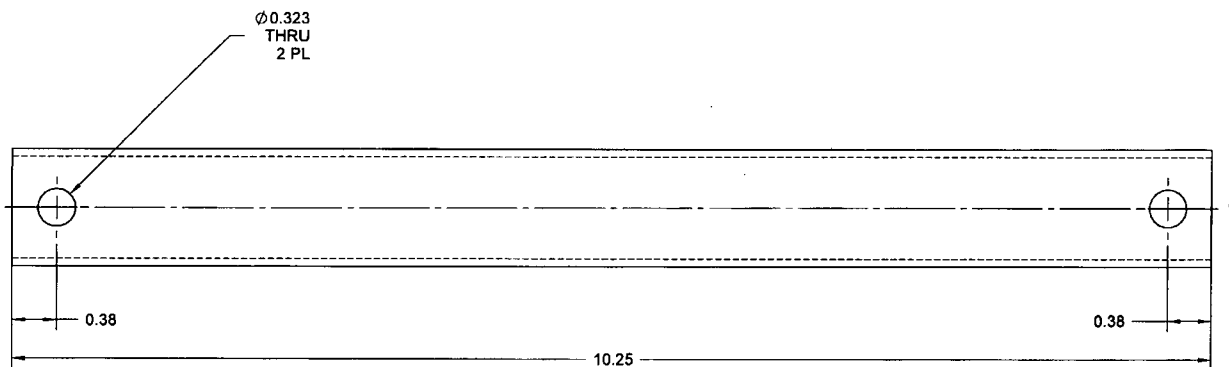
D3768-4 FRONT OUTBOARD LEG, RH

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NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A		NEW ISSUE		HS	08.06.04
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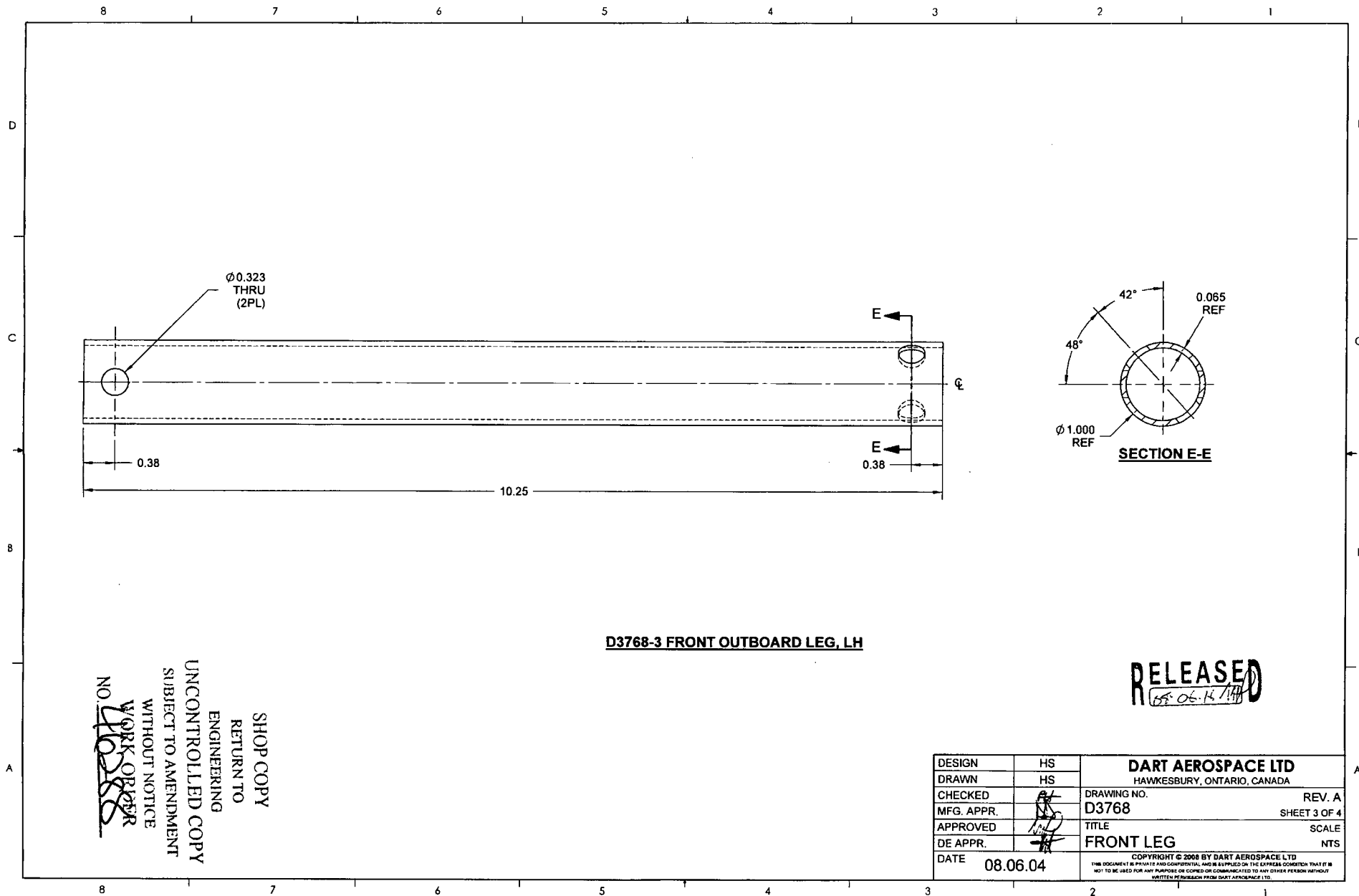


D3768-1 FRONT INBOARD LEG

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D3768-3 FRONT OUTBOARD LEG, LH

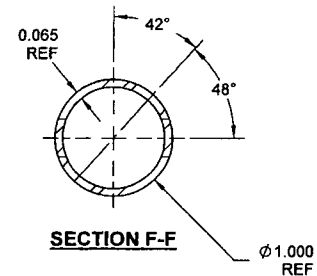
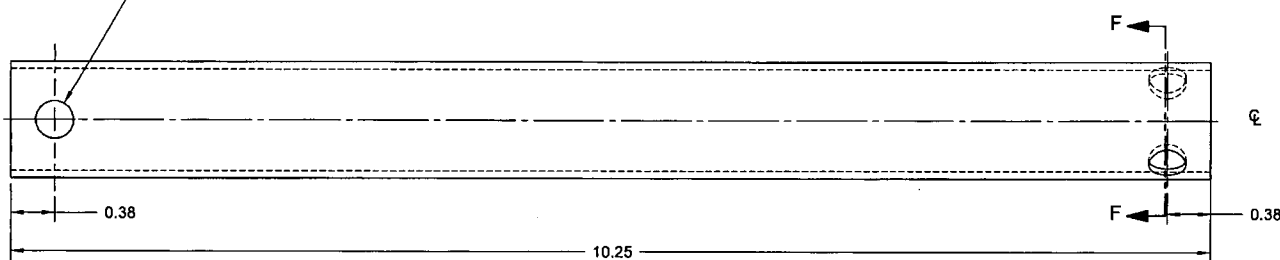
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DATE	08.06.04		

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THRU
2 PL



D3768-4 FRONT OUTBOARD LEG, RH

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08-06-04

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